

THE INSTITUTE OF PAPER CHEMISTRY, APPLETON, WISCONSIN

CONTINUOUS BASE-LINE STUDY (MODIFIED)  
(MILL CORRUGATING MEDIUM DATA FOR JULY, AUGUST, SEPTEMBER, 1984)

✓ Project 2694-2

Report Fifty-Seven

A Progress Report

to

FOURDRINIER KRAFT BOARD GROUP

OF THE

AMERICAN PAPER INSTITUTE

December 1, 1984

BASE-LINE  
3rd QUARTER, 1984

THE INSTITUTE OF PAPER CHEMISTRY

Appleton, Wisconsin

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Appleton, Wisconsin

CONTINUOUS BASE-LINE STUDY (MODIFIED)  
(MILL CORRUGATING MEDIUM DATA FOR JULY, AUGUST, SEPTEMBER, 1984)

SUMMARY OF 26-LB CORRUGATING MEDIUM DATA  
(JUN-SEP, ER, )

Test		JUN		JUL		AUG		SEP	
		Total	Recycled	Total	Recycled	Total	Recycled	Total	Recycled
Moisture content, %	Max.	9.8	7.2	9.6	7.6	9.6	7.2	9.8	7.0
	Min.	4.3	4.3	3.6	3.6	3.6	3.6	3.7	3.7
	Ave.	6.7(34)	5.8(13)	6.7(33)	5.8(12)	6.6(32)	5.7(12)	6.6(33)	5.7(12)
Adj. basis weight, lb/M sq ft	Max.	27.3	27.3	27.3	27.3	27.2	27.2	27.2	27.2
	Min.	25.3	26.0	25.3	26.0	25.2	26.3	25.1	26.1
	Ave.	26.3(34)	26.6(13)	26.4(33)	26.6(12)	26.4(32)	26.6(12)	26.4(33)	26.6(12)
Caliper, pt.	Max.	11.5	11.5	11.2	11.2	11.7	11.7	11.2	11.2
	Min.	7.8	7.8	7.8	7.8	7.9	7.9	7.7	7.7
	Ave.	9.6(28)	9.4(12)	9.6(27)	9.4(11)	9.6(26)	9.5(11)	9.5(27)	9.4(11)
Concora, lb	Max.	71.0	68.8	70.0	68.5	69.0	69.0	70.1	70.1
	Min.	51.5	51.5	51.5	51.5	51.5	51.5	51.3	51.3
	Ave.	60.7(34)	59.9(13)	60.9(33)	60.5(12)	61.0(32)	60.7(12)	61.1(33)	60.5(12)
CD Ring Crush, lb	Max.	39.0	34.0	41.0	36.0	39.0	36.0	42.0	39.0
	Min.	20.0	20.0	23.0	28.0	25.0	27.0	25.0	26.5
	Ave.	29.9(24)	27.0( 8)	30.9(19)	30.5( 4)	31.0(20)	29.7( 5)	31.6(21)	30.3( 5)

Max. and Min. values are current machine averages.

Ave. value is current F.K.B.G. average, number of machines is indicated in parentheses.

## INTRODUCTION

The continuous base-line study (modified) is a compilation of monthly averages of mill test data obtained routinely on 26-lb corrugating medium manufactured in the member mills of F.K.B.G. Mill data are included for moisture content, basis weight, caliper, Concora, and C.D. Ring Crush made on the production of individual machines which produced at least 500 tons of this grade weight during a given month.

## PRESENTATION OF DATA

For the 26-lb grade weight of corrugating medium referred to earlier, data on conditioning and testing environments, mill test averages for moisture content, adjusted basis weight, caliper, Concora, and C.D. Ring Crush results are compiled in the following tables.

Table Number	Description
I-II-III-IV	Mill Test Averages on 26-Lb Corrugating Medium
V	Data on Conditioning and Testing Environments

The procedure used in calculating cumulative machine averages, machine factors, machine indexes, and F.K.B.G. indexes are described in the Appendix.

It should be explained that the number of machines for which data are compiled in each table for a specified month varies for these reasons: a machine must have (a) produced at least 500 tons of 26-lb corrugating medium during the specified month, or (b) produced 500 tons of 26-lb corrugating medium during any one or more of the 12 months prior to the specified month (so that a cumulative average is available), to be included in a given table.

TABLE I  
AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM  
JULY, 1984

CODE *E	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT., *A LB./ M SQ. FT.				CALIPER, PT.				CONCORDA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
D1(R)	6.0	6.0	100.0	90.9	26.5	26.7	99.2	100.4	9.0	9.0	100.0	94.7	51.8	52.4	98.8	84.9
J1	7.1	7.0	101.4	107.6	26.7	26.8	99.6	101.1	9.4	9.0	104.4	98.9	62.3	65.3	95.4	102.1
K1(R)	5.9	5.8	101.7	89.4	26.6	26.5	100.4	100.8	10.5	10.4	101.0	110.5	61.9	60.4	102.5	101.5
P1	6.0	6.1	98.4	90.9	26.7	26.7	100.0	101.1		0.0			59.0	60.1	98.2	96.7
Q1	7.4	7.5	98.7	112.1	26.4	26.4	100.0	100.0		0.0			59.0	58.8	100.3	96.7
R1	6.8	7.0	97.1	103.0	26.9	26.4	101.9	101.9	8.7	8.8	98.9	91.6	70.0	69.3	101.0	114.8
W1	7.5	7.4	101.4	113.6	26.5	26.5	100.0	100.4	9.8	10.4	94.2	103.2	56.0	56.8	98.6	91.8
A2	9.6	9.5	101.0	145.4	25.3	25.4	99.6	95.8	10.1	9.7	104.1	106.3	62.8	64.1	98.0	103.0
D2	6.8	6.5	104.6	103.0	26.2	26.4	99.2	99.2	9.4	9.5	98.9	98.9	65.0	64.1	101.4	106.6
G2	6.9	6.9	100.0	104.5	26.3	26.3	100.0	99.6		0.0			62.0	62.6	99.0	101.6
Q2(R)	7.1	7.1	100.0	107.6	26.2	26.2	100.0	99.2	11.2	11.7	95.7	117.9	62.7	62.4	100.5	102.8
S2(R)	5.8	5.8	100.0	87.9	26.6	26.6	100.0	100.8	9.5	9.8	96.9	100.0	59.9	60.7	98.7	98.2
W2		6.6				26.1				8.7				67.1		
Y2	6.7	6.8	98.5	101.5	26.3	26.4	99.6	99.6	9.7	10.1	96.0	102.1	59.0	59.2	99.7	96.7
Z2	8.6	8.4	102.4	130.3	25.9	26.1	99.2	98.1	10.4	10.2	102.0	109.5	60.7	62.8	96.6	99.5
A3(R)	6.1	6.1	100.0	92.4	26.5	26.4	100.4	100.4	9.1	9.1	100.0	95.8	64.0	63.2	101.3	104.9
B3	6.6	6.6	100.0	100.0	26.5	26.5	100.0	100.4	9.8	8.8	111.4	103.2	62.2	64.1	97.0	102.0
F3(R)	5.2	4.9	106.1	78.8	26.7	26.8	99.6	101.1	9.2	9.4	97.9	96.8	58.1	59.5	97.6	95.2
H3(R)	3.6	4.5	80.0	54.5	27.1	26.9	100.7	102.6	9.0	9.2	97.8	94.7	60.0	59.4	101.0	98.4
J3	7.1	7.2	98.6	107.6	26.1	26.3	99.2	98.9	10.0	10.4	96.2	105.3	62.0	60.9	101.8	101.6
K3	7.2	7.8	92.3	109.1	26.1	26.2	99.6	98.9		0.0			57.0	59.7	95.5	93.4
K3		6.7				26.2				8.0				68.5		
T3(R)	5.3	4.8	110.4	80.3	26.7	26.9	99.2	101.1	7.8	7.8	100.0	82.1	59.1	59.7	99.0	96.9
V3	8.8	7.7	114.3	133.3	25.7	26.2	98.1	97.3		0.0			57.0	56.4	101.1	93.4
D4(R)		5.8				25.7				8.9				56.5		
E4(R)	7.0	7.0	100.0	106.1	26.3	26.3	100.0	99.6	9.3	9.3	100.0	97.9	68.5	69.6	98.4	112.3
F4	6.8	6.3	107.9	103.0	26.1	26.0	100.4	98.9	8.8	8.6	102.3	92.6	69.0	67.0	103.0	113.1
G4	7.2	7.1	101.4	109.1	26.3	26.4	99.6	99.6	10.6	10.6	100.0	111.6	59.8	60.4	99.0	98.0
H4	6.3	6.1	103.3	95.4	26.1	26.4	98.9	98.9	9.8	9.8	100.0	103.2	61.0	60.4	101.0	100.0
I4	8.7	8.6	101.2	131.8	26.0	26.0	100.0	98.5	9.8	8.9	110.1	103.2	62.0	61.1	101.5	101.6
M4	7.2	7.2	100.0	109.1	26.6	26.4	100.8	100.8	10.1	10.2	99.0	106.3	56.0	56.7	98.8	91.8
N4	6.6	6.9	95.6	100.0	26.3	26.4	99.6	99.6	8.8	9.3	94.6	92.6	60.8	61.1	99.5	99.7
P4	6.0	5.8	103.4	90.9	25.8	25.9	99.6	97.7	9.6	9.8	98.0	101.0	60.5	59.9	101.0	99.2
Q4(R)	4.7	4.2	111.9	71.2	27.3	27.2	100.4	103.4	9.0	9.0	100.0	94.7	51.5	52.9	97.4	84.4
R4(R)	7.6	7.0	108.6	115.2	26.0	26.3	98.8	98.5		0.0			62.0	61.8	100.3	101.6
U4(R)	5.8	5.8	100.0	87.9	26.3	26.4	99.6	99.6	9.5	9.5	100.0	100.0	66.8	64.6	103.4	109.5

FXBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.7	5.8	26.4	26.6	9.6	9.4	60.9	60.5
CUM. AV	6.6	5.8	26.4	26.5	9.5	9.4	61.0	60.2
IND. *D	101.5	100.0	100.0	100.4	101.0	100.0	99.8	100.5

(\*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE II  
AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM

AUGUST, 1984

CODE *E	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT., *A LB./ M SQ. FT.				CALIPER, PT.				CONCOPA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
U1(R)	6.0	6.0	100.0	90.9	26.3	26.7	98.5	99.6	9.0	9.0	100.0	94.7	51.8	52.3	99.0	84.8
J1	6.8	6.9	98.6	103.0	27.1	26.8	101.1	102.6	8.8	9.0	97.8	92.6	66.8	65.1	102.6	109.3
K1(R)	5.8	5.8	100.0	87.9	26.5	26.5	100.0	100.4	10.3	10.4	99.0	108.4	60.7	60.6	100.2	99.3
P1	6.1	6.0	101.7	92.4	26.7	26.7	100.0	101.1	0.0				59.0	60.0	98.3	96.6
Q1	7.5	7.4	101.4	113.6	26.2	26.4	99.2	99.2	0.0				60.0	58.8	102.0	98.2
R1	6.2	7.0	88.6	93.9	26.7	26.4	101.1	101.1	8.6	8.7	98.8	90.5	67.0	69.4	96.5	109.6
W1	7.4	7.4	100.0	112.1	26.5	26.5	100.0	100.4	10.2	10.3	99.0	107.4	57.0	56.8	100.4	93.3
A2	9.6	9.5	101.0	145.4	25.2	25.4	99.2	95.4	10.0	9.8	102.0	105.3	63.2	64.0	98.8	103.4
D2	6.8	6.6	103.0	103.0	26.2	26.3	99.6	99.2	9.5	9.5	100.0	100.0	62.0	64.1	96.7	101.5
G2	6.9	6.9	100.0	104.5	26.2	26.3	99.6	99.2	0.0				62.0	62.5	99.2	101.5
Q2(R)	7.2	7.1	101.4	109.1	26.4	26.2	100.8	100.0	11.7	11.6	100.9	123.2	64.0	62.4	102.6	104.7
S2(R)	5.8	5.8	100.0	87.9	26.6	26.6	100.0	100.8	9.9	9.8	101.0	104.2	60.5	60.6	99.8	99.0
W2		6.6				26.1				8.7				67.1		
Y2	6.9	6.8	101.5	104.5	26.3	26.4	99.6	99.6	9.7	10.0	97.0	102.1	60.0	59.2	101.4	98.2
Z2	8.0	8.5	94.1	121.2	26.0	26.1	99.6	98.5	10.3	10.2	101.0	108.4	61.3	62.6	97.9	100.3
A3(R)	6.2	6.1	101.6	93.9	26.6	26.4	100.8	100.8	9.1	9.1	100.0	95.8	65.0	63.5	102.4	106.4
U3	6.7	6.6	101.5	101.5	26.4	26.5	99.6	100.0	10.0	8.8	113.6	105.3	62.1	64.0	97.0	101.6
F3(R)	4.6	4.9	93.9	69.7	26.7	26.8	99.6	101.1	9.5	9.3	102.2	100.0	60.6	59.4	102.0	99.2
H3(R)	3.6	4.4	81.8	54.5	27.1	26.9	100.7	102.6	9.5	9.2	103.3	100.0	61.5	59.4	103.5	100.6
J3	7.3	7.2	101.4	110.6	25.9	26.3	98.5	98.1	10.1	10.3	98.0	106.3	61.0	60.9	100.2	99.8
A3	7.3	7.7	94.8	110.6	26.1	26.2	99.6	98.9		0.0			61.0	59.7	102.2	99.8
R3		6.7				26.2				8.0				66.5		
T3(R)	5.3	5.0	106.0	80.3	26.6	26.8	99.2	100.8	7.9	7.8	101.3	83.2	58.8	59.6	98.6	96.2
V3	7.6	7.8	97.4	115.2	26.6	26.2	101.5	100.8		0.0			59.0	56.4	104.6	96.6
U4(R)		5.8				25.7				8.8				56.7		
E4(R)	7.0	7.0	100.0	106.1	26.3	26.3	100.0	99.6	9.2	9.3	98.9	96.8	69.0	69.6	99.1	112.9
F4		6.4				26.0				8.6				67.8		
G4	7.3	7.1	102.8	110.6	26.3	26.4	99.6	99.6	10.5	10.6	99.0	110.5	59.8	60.3	99.2	97.9
H4	6.4	6.1	104.9	97.0	26.2	26.3	99.6	99.2	9.9	9.8	101.0	104.2	60.0	60.6	99.0	98.2
I4	8.7	8.7	100.0	131.8	26.0	26.0	100.0	98.5	9.8	9.0	108.9	103.2	62.0	61.2	101.3	101.5
M4	7.2	7.2	100.0	109.1	26.6	26.5	100.4	100.8	10.0	10.2	98.0	105.3	56.0	56.6	98.9	91.6
N4	6.6	6.8	97.0	100.0	26.3	26.4	99.6	99.6	8.8	9.3	94.6	92.6	62.0	61.1	101.5	101.5
P4	6.1	5.8	105.2	92.4	25.8	25.9	99.6	97.7	9.4	9.7	96.9	98.9	61.4	60.0	102.3	100.5
Q4(R)	4.4	4.3	102.3	66.7	27.2	27.2	100.0	103.0	9.0	9.0	100.0	94.7	51.5	52.9	97.4	84.3
R4(R)	6.7	7.0	95.7	101.5	26.4	26.3	100.4	100.0		0.0			61.0	61.9	98.5	99.8
U4(R)	5.8	5.8	100.0	87.9	26.3	26.4	99.6	99.6	9.5	9.5	100.0	100.0	63.8	64.8	98.4	104.4

FKBG DATA

	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED	TOTAL	RECYCLED
CUR. AV	6.6	5.7	26.4	26.6	9.6	9.5	61.0	60.7
CUM. AV	6.6	5.8	26.4	26.5	9.5	9.4	61.1	60.3
IND. *D	100.0	98.3	100.0	100.4	101.0	101.1	99.8	100.7

(\*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.



TABLE III  
AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM  
SEPTEMBER, 1984

CODE *E	MOISTURE CONTENT, PERCENT				ADJ. BASIS WT., *A LB./ M SQ. FT.				CALIPER, PT.				CONCOKA TEST LB.			
	MACHINE DATA				MACHINE DATA				MACHINE DATA				MACHINE DATA			
	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C	CUR. AV.	CUM. AV.	FACT. *B	IND. *C
D1(R)	6.0	6.0	100.0	90.9	26.7	26.6	100.4	101.1	9.0	9.0	100.0	93.8	51.3	52.2	98.3	84.0
J1	6.8	6.9	98.6	103.0	26.9	26.9	100.0	101.9	8.7	9.0	96.7	90.6	66.7	65.0	102.6	109.2
K1(R)	5.8	5.8	100.0	87.9	26.5	26.5	100.0	100.4	10.5	10.4	101.0	109.4	60.7	60.6	100.2	99.3
P1	5.9	6.0	98.3	89.4	26.8	26.7	100.4	101.5	0.0				59.0	59.9	98.5	96.6
Q1	7.3	7.5	97.3	110.6	26.4	26.4	100.0	100.0	0.0				57.0	56.9	96.8	93.3
R1	6.6	7.0	94.3	100.0	26.5	26.4	100.4	100.4	8.7	8.7	100.0	90.6	66.0	69.2	95.4	108.0
W1	7.5	7.4	101.4	113.6	26.1	26.6	98.1	98.9	10.2	10.3	99.0	106.2	58.0	56.8	102.1	94.9
A2	9.8	9.5	103.2	148.5	25.1	25.4	98.8	95.1	9.9	9.8	101.0	103.1	64.4	64.0	100.6	105.4
D2	6.8	6.6	103.0	103.0	26.2	26.3	99.6	99.2	9.6	9.5	101.0	100.0	64.0	63.8	100.3	104.7
G2	6.8	6.9	98.6	103.0	26.3	26.3	100.0	99.6	0.0				64.0	62.5	102.4	104.7
Q2(R)	6.9	7.1	97.2	104.5	26.1	26.2	99.6	98.9	11.2	11.6	96.6	116.7	62.7	62.6	100.2	102.6
S2(R)	5.8	5.8	100.0	87.9	26.6	26.6	100.0	100.8	9.8	9.8	100.0	102.1	59.8	60.6	98.7	97.9
W2		6.6				26.1				8.7				67.0		
Y2	6.9	6.8	101.5	104.5	26.4	26.4	100.0	100.0	9.9	10.1	98.0	103.1	59.0	59.4	99.3	96.6
Z2	8.4	8.4	100.0	127.3	25.8	26.1	98.8	97.7	10.6	10.2	103.9	110.4	61.6	62.4	98.7	100.8
A3(R)	6.2	6.1	101.6	93.9	26.7	26.4	101.1	101.1	9.0	9.1	98.9	93.8	65.0	63.6	102.2	106.4
B3	6.6	6.6	100.0	100.0	26.6	26.5	100.4	100.8	9.6	8.9	107.9	100.0	63.0	63.9	98.6	103.1
F3(R)	4.4	4.8	91.7	66.7	26.9	26.8	100.4	101.9	9.0	9.3	96.8	93.8	60.6	59.5	101.8	99.2
H3(R)	3.7	4.4	84.1	56.1	27.1	26.9	100.7	102.6	9.1	9.2	98.9	94.8	60.0	59.7	100.5	98.2
J3	7.2	7.2	100.0	109.1	26.2	26.2	100.0	99.2	10.0	10.3	97.1	104.2	62.0	60.8	102.0	101.5
K3	7.3	7.6	96.0	110.6	26.1	26.2	99.6	98.9	0.0				58.0	59.8	97.0	94.9
R3		6.7				26.2				8.0				68.5		
T3(R)	5.4	5.1	105.9	81.8	26.6	26.8	99.2	100.8	7.7	7.8	98.7	80.2	59.7	59.5	100.3	97.7
V3	7.8	7.8	100.0	118.2	26.0	26.2	99.2	98.5	0.0				60.0	56.5	106.2	98.2
D4(R)		5.8				25.6				8.9				57.0		
E4(R)	7.0	7.0	100.0	106.1	26.6	26.3	101.1	100.8	9.4	9.2	102.2	97.9	70.1	69.6	100.7	114.7
F4	6.5	6.4	101.6	98.5	26.0	26.0	100.0	98.5	8.4	8.6	97.7	87.5	67.0	67.8	98.8	109.6
G4	7.2	7.1	101.4	109.1	26.3	26.4	99.6	99.6	11.2	10.6	105.7	116.7	59.6	60.3	98.8	97.5
H4	6.4	6.2	103.2	97.0	26.1	26.3	99.2	98.9	9.9	9.8	101.0	103.1	60.0	60.5	99.2	98.2
I4	8.7	8.7	100.0	131.8	25.9	26.0	99.6	98.1	9.5	9.1	104.4	99.0	61.0	61.3	99.5	99.8
M4	7.2	7.2	100.0	109.1	26.5	26.5	100.0	100.4	9.9	10.2	97.0	103.1	58.0	56.5	102.6	94.9
N4	6.6	6.8	97.0	100.0	26.3	26.3	100.0	99.6	8.9	9.2	96.7	92.7	61.0	61.1	99.8	99.8
P4	6.0	5.9	101.7	90.9	25.8	25.8	100.0	97.7	9.5	9.7	97.9	99.0	60.3	60.0	100.5	98.7
U4(R)	4.5	4.3	104.6	68.2	27.2	27.2	100.0	103.0	9.0	9.0	100.0	93.8	51.3	52.8	97.2	84.0
R4(R)	6.8	7.0	97.1	103.0	26.5	26.3	100.8	100.4	0.0				62.0	61.8	100.3	101.5
U4(R)	5.8	5.8	100.0	87.9	26.3	26.4	99.6	99.6	9.5	9.5	100.0	99.0	63.0	64.8	97.2	103.1

FKBG DATA		TOTAL		RECYCLED		TOTAL		RECYCLED		TOTAL		RECYCLED		TOTAL		RECYCLED	
CUR. AV	6.6		5.7		26.4		26.6		9.5		9.4		61.1		60.5		
CUM. AV	6.6		5.8		26.4		26.5		9.6		9.4		61.1		60.4		
IND. *D	100.0		98.3		100.0		100.4		99.0		100.0		100.0		100.2		

(\*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE IV

AVERAGES OF ROUTINE MILL QUALITY CONTROL DATA FOR 26 LB. CORRUGATING MEDIUM  
RING COMPRESSION, LBS.


	JULY, 1984				AUGUST, 1984				SEPTEMBER, 1984			
	CUR. AV.	MACHINE DATA CUM. AV.	FACT. *B	IND. *C	CUR. AV.	MACHINE DATA CUM. AV.	FACT. *B	IND. *C	CUR. AV.	MACHINE DATA CUM. AV.	FACT. *B	IND. *C
D1(R)		20.3				20.5				20.6		
J1												
K1(R)												
P1	30.0	34.9	86.0	101.4	27.0	34.4	78.5	90.6	34.0	33.8	100.6	113.3
Q1	28.0	26.2	106.9	94.6	28.0	26.4	106.1	94.0	27.0	26.6	101.5	90.0
R1												
M1	31.0	27.8	111.5	104.7	30.0	28.0	107.1	100.7	29.0	28.1	103.2	96.7
A2	33.2	33.6	98.8	112.2	31.1	33.6	92.6	104.4	30.0	33.3	90.1	100.0
O2	32.0	31.6	101.3	108.1	34.0	31.2	109.0	114.1	32.0	30.9	103.6	106.7
G2	27.0	30.4	88.8	91.2	30.0	30.1	99.7	100.7	30.0	30.0	100.0	100.0
Q2(R)	28.0	26.4	106.1	94.6	28.0	26.7	104.9	94.0	29.0	26.8	108.2	96.7
S2(R)												
M2												
Y2		28.7				28.9				29.1		
Z2	35.9	35.8	100.3	121.3	38.3	35.8	107.0	128.5	36.6	36.3	100.8	122.0
A3(R)	36.0	34.3	105.0	121.6	36.0	34.5	104.3	120.8	39.0	35.1	111.1	130.0
B3		28.9				29.2				29.3		
F3(R)		26.1			27.0	26.2	103.0	90.6	26.5	26.4	100.4	88.3
H3(R)		25.0				25.2				25.2		
J3	41.0	33.4	122.8	138.5	39.0	34.1	114.4	130.9	42.0	34.7	121.0	140.0
K3	23.0	28.2	81.6	77.7	25.0	27.9	89.6	83.9	25.0	27.7	90.2	83.3
R3												
T3(R)	29.4	29.8	98.6	99.3	29.6	29.8	99.3	99.3	29.3	29.8	98.3	97.7
V3	26.0	29.8	87.2	87.8	29.0	29.5	98.3	97.3	30.0	29.2	102.7	100.0
D4(R)		33.9				33.9				33.9		
E4(R)												
F4												
G4	34.8	34.6	100.6	117.6	34.3	34.6	99.1	115.1	35.0	34.7	100.9	116.7
H4	29.0	26.8	108.2	98.0	30.0	27.0	111.1	100.7	31.0	27.4	113.1	103.3
I4	37.0	33.2	111.4	125.0	37.0	33.8	109.5	124.2	36.0	34.2	105.3	120.0
M4	28.0	27.3	102.6	94.6	29.0	27.2	106.6	97.3	28.0	27.1	103.3	93.3
N4									35.0			116.7
P4	29.4	33.3	88.3	99.3	31.0	32.8	94.5	104.0	31.8	32.6	97.5	106.0
Q4(R)		25.3				25.4				25.5		
R4(R)												
U4(R)	28.7	29.9	96.0	97.0	27.8	29.8	93.3	93.3	27.8	29.7	93.6	92.7
FKBG DATA												
	TOTAL	RECYCLED			TOTAL	RECYCLED			TOTAL	RECYCLED		
CUR. AV	30.9	30.5			31.0	29.7			31.6	30.3		
CUM. AV	29.6	27.6			29.8	28.0			30.0	28.2		
IND. *D	104.4	110.5			104.0	106.1			105.3	107.4		

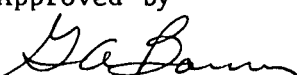
(\*)-- NOTES A, B, C, D, AND E, ARE GIVEN IN APPENDIX.

TABLE V  
DATA ON CONDITIONING AND TESTING ENVIRONMENTS  
JULY, AUGUST, SEPTEMBER, 1984

Code	Conditioning Environment				Testing Environment
	Are Quality Samples Conditioned Before Testing?	Time	Temp., °F	RH, %	Are Quality Samples Tested Under Controlled Conditions of Temperature & Humidity?
D1	No	--	--	--	Yes: 73 ± 3°F; 50 ± 2% RH
J1	No	--	--	--	No
K1	No	--	--	--	Yes: 72 ± 4°F; 50 ± 5% RH
P1	No	--	--	--	Yes: 72 ± 3°F; 50 ± 4% RH
Q1	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
R1	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
W1	No	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
A2	No	--	--	--	Yes: 72 ± 2°F; 50 ± 2% RH
D2	No	--	--	--	Yes: 73°F; 50% RH
G2	No	--	--	--	Yes: 72 ± 3°F; 50 ± 4% RH
Q2	Yes	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
S2	No	--	--	--	Yes: 72 ± 4°F; 50 ± 5% RH
W2	No data was submitted for this quarter				No
Y2	No	--	--	--	Yes: 72 ± 3°F; 50 ± 2% RH
Z2	No	--	--	--	No
A3	No	--	--	--	Yes: 72 ± 2°F; 50 ± 2% RH
B3	Yes	20 min	--	--	No
F3	No	--	--	--	No
H3	No	--	--	--	Yes: 72 ± 2°F; 50 ± 1% RH
J3	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
K3	No	--	--	--	Yes: 75 ± 2°F; 50 ± 2% RH
R3	No data was submitted for this quarter				Yes: 73 ± 2°F; 50 ± 2% RH
T3	No	--	--	--	
V3	No	--	--	--	
D4	No data was submitted for this quarter				Yes: 72 ± 1°F; 50 ± 1% RH
E4	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
F4	No	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
G4	No	--	--	--	Yes
H4	No	--	--	--	Yes: 70 ± 2°F; 50 ± 10% RH
I4	No	--	--	--	Yes: 70 ± 2°F; 50 ± 2% RH
M4	No	--	--	--	No
N4	No	--	--	--	Yes: 73 ± 2°F; 50 ± 2% RH
P4	No	--	--	--	Yes: 73 ± 3°F; 50 ± 2% RH
Q4	No	--	--	--	Yes: 70 ± 2°F; 50 ± 5% RH
R4	No	--	--	--	Yes: 72 ± 2°F; 50 ± 3% RH
U4	No	--	--	--	

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# APPENDIX

## NOTES A, B, C, D, AND E, USED IN TABULATIONS OF MILL DATA

Notes A, B, C, D, and E, used in the tables of mill data are given below; these notes define the procedure used in calculating adjusted basis weight, machine factor, machine index, and F.K.B.G. index. It should be stressed that each formula is applicable only to a specific physical property of corrugating medium.

Note A: Adjusted basis weight (ABW) = reported weight (RBW) adjusted to moisture content of 7.8%:

$$ABW = RBW \left[ \frac{(100 - \text{reported moisture content, \%})}{(100 - 7.8)} \right]$$

Note B: Machine factor (%) =  $\left[ \frac{\text{Current machine average}}{\text{Cumulative machine average}} \right] \cdot 100$  where

$$\text{Cumulative machine average} = \sum \frac{\text{CMA's}^a \text{ for previous 12 months excluding CMA for current month}}{12}$$

Note C: Machine index (%) =  $\left[ \frac{\text{Current machine average}}{\text{Cumulative F.K.B.G. total average}} \right] \cdot 100$  where

$$\text{Cumulative F.K.B.G. average} = \sum \frac{\text{CFKBGA's}^b \text{ for previous 12 months excluding CFKBGA for current month}}{12}$$

Note D: F.K.B.G. index (%) =  $\left[ \frac{\text{Current F.K.B.G. average}}{\text{Cumulative F.K.B.G. average}} \right] \cdot 100$  where

$$\text{Current F.K.B.G. average} = \sum \frac{\text{CMA's}^a \text{ for current month for all machines}}{\text{Number of machines}}$$

Note E: (R) - Indicates a medium manufactured from recycled fibers.

<sup>a</sup>CMA = current machine average for a specific physical property of 26-lb corrugating medium obtained during a given month on a specific machine.

<sup>b</sup>CFKBGA = current F.K.B.G. average for a specific physical property of 26-lb corrugating medium obtained during a given month.